

Date: Tuesday, 05/05/2009 8:46:27 AM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services				Drawing Name	: BUSHING	
Job Number	: 47733				Part Number	: D2809	
Estimate Number	: 11041				Drawing Number	: D2809 REV A1	
P.O. Number	:				Project Number	: N/A	
This Issue	: 05/05/2009		S.O. No.	: :	Drawing Revision	: A1	
Prsht Rev.	: NC				Material	:	
First Issue	: / /		Type	: MACHINED PARTS	Due Date	: 12/05/2009	
Previous Run	: 46438				Qty:	50 Um: Each	
Written By	:						
Checked & Approved By	: <u>MNF 09-05-05</u>						
Comment	: Est C 02.03.07 Now turned in house NG						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6R0500	6061-T6 Round Bar .500" <u>SD 09/05/10</u>
		Comment: Qty.: 0.1045 f(s)/Unit Total : 5.2238 f(s) 6061-T6 Round Bar .500" Material: 6061-T6 (QQ-A-250-11) rod .500"Ø Batch: <u>M111448</u>
2.0	HARDINGE	HARDINGE CNC LATHE SMALL <u>SD 09/05/10</u>
		Comment: HARDINGE CNC LATHE SMALL Machine as per Folio FA204
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE <u>SD 09/05/10</u>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>SD 09/05/10</u>
4.0	QC8	SECOND CHECK <u>SD 09/05/10</u>
		Comment: SECOND CHECK <u>SD 09/05/10</u>
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 <u>SD 09/05/10</u>
		Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <u>SD 09/05/10</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 05/05/2009 8:46:27 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 47733

Part Number: D2809

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder coat WHITE per QSI 005 4.3

START TIME: 9:55

OVEN TEMPERATURE: 320

FINISH TIME: 10:25

MD 09/05/00

x56

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

04-05-20

x56

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 49

95/21

56x

56x

56x

56x

56x

56x

9.0 QC21

FINAL INSPECTION/W/O RELEASE



09/05/21

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-05-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	47733
Description: Spacer	Part Number:	D2809
Inspection Dwg: D2809 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

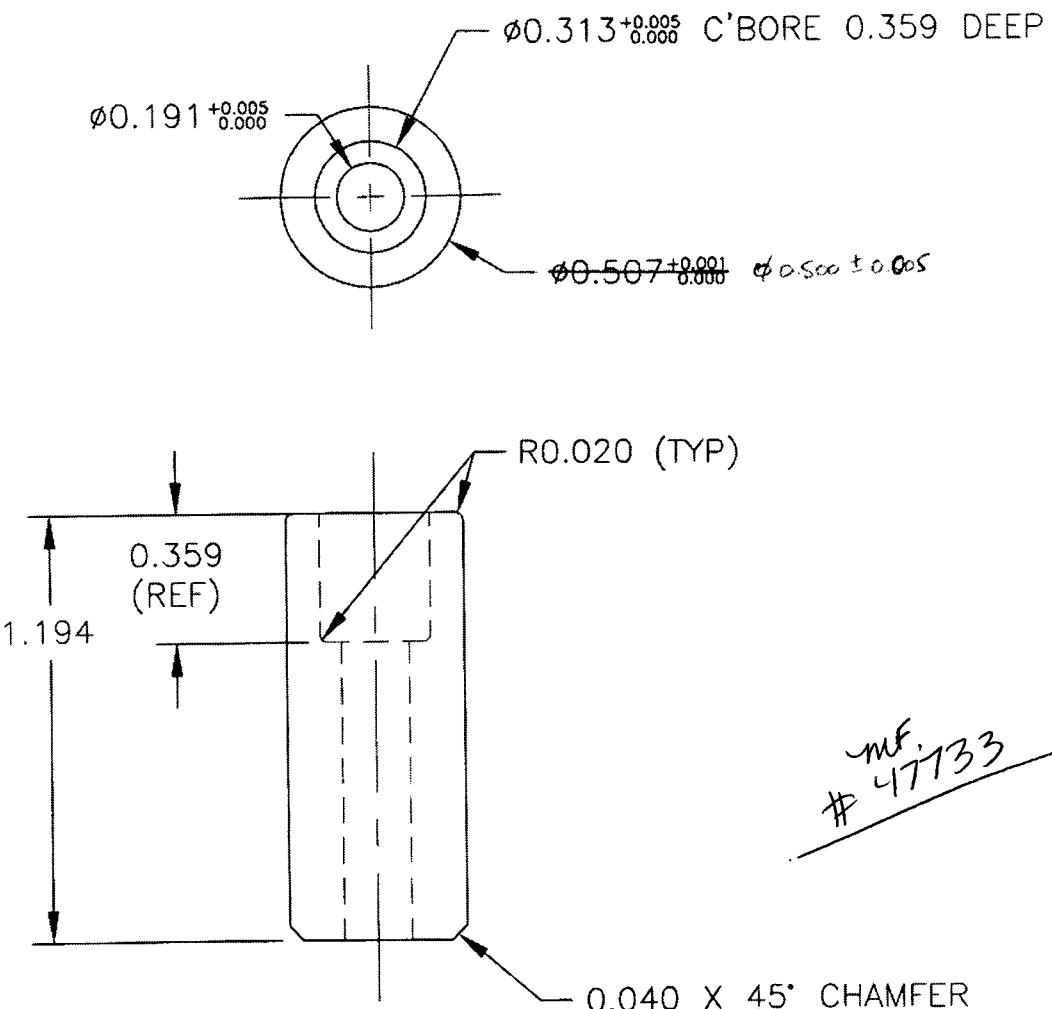
Measured by: <u>SA</u>	Audited by: <u>2nd</u>	Prototype Approval: N/A
Date: <u>09/08/10</u>	Date: <u>09/05/15</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM 	

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
CP	H	D2809	SHEET 1 OF 1
DATE		TITLE	SCALE
00.11.07		SPACER	2:1
A	00.11.07	NEW ISSUE	
A1	CP 01.04.26	APP. POWDER COAT; $\phi 0.500$ MIN: $\phi 0.507$	

RELEASED
DO. 11-13 01



TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 BREAK ALL UNMARKED SHARP CORNERS 0.010 TO 0.020
 MATERIAL: 6061-T6 (QQ-A-250/11) OR (QQ-A-225/8)
 FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT WHITE (4351) OR GREY SANDTEX (4356) OR BLACK SANDTEX (4357) OR GREEN TANDEX (4758)

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